

☆ for flight test x2

Work Order ID 155062

155062

Page 1

Item ID: D5354-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: R66 Fwd Clamp Assembly, LH
Start Date: 01/06/2017 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 01/11/2017 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5354	B

100		0.01							DAS 14 9-89
100	BAND SAW					2	0		
Bandsaw	Memo	0.03							
Jeaspa Bandsaw	Cut Blanks at 4.250"								17/01/07

110		0.01							DAS 14 9-89
110	HAAS CNC VERTICAL MACHINING #1					2	0		
HAAS 5AXIS	Memo	0.11							
HAAS CNC vertical machine #5	1-Machine per folio FB436 (D5354-1) DWG REV: <u>3</u> FOLIO REV: <u>AA</u>								17/01/08

2- deburr and break all sharp edge as per dwg

Work Order ID 155062***155062***

Page 2

Item ID: D5354-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: R66 Fwd Clamp Assembly, LH

Start Date: 01/06/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 01/11/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC1- Inspection performed by CMM Memo Inspect on CMM as per folio CMMA026. DWG REV: _____ CMM PROG. REV: _____	0.01 0.06				<u>2</u>	<u>0</u>		DAS 14 9-89 17/01/08
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01				<u>2</u>	<u>0</u>		DAS 44 9-89 17-01-09
140 *140* Outsource4 Outsource process - Anodize	Outsource process- Anodize per QS1017 4.1.10.1 Memo Issue P/O to ATG : _____ Black Anodize as per Dwg D5354 Certification of Conformity is required.	0.00 24.00							N/A 2nd

Work Order ID 155062***155062***

Page 3

Friday, January 06, 2017 10:43:18 AM

Item ID: D5354-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: R66 Fwd Clamp Assembly, LH
Start Date: 01/06/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 01/11/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo Certification of Conformity is required.	0.00 0.01				_____	_____	_____	_____
155 *155* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				_____	_____	_____	_____

N/A

Work Order ID 155062***155062***

Page 4

Item ID: D5354-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: R66 Fwd Clamp Assembly, LH

Start Date: 01/06/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 01/11/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.01							
160					DAS 30 9-89	2			JAN 10 2017
Small Fab	Memo	0.06							
Small Fab	-Assemble as per dwg.				DAS 36 9-89				
	-Secure nuts as per dwg. (Note #8)								
	-Apply proseal as per dwg.								
	Batch: 136076								
	Exp. date: 5/17								
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.01							
Quality Control									

POSITIVE RECALL

EFFECTIVE 17-01-11 AUTH

RELEASED _____ DATE _____

DAS
9
9-89Flight
test

Work Order ID 155062***155062***

Page 5

Item ID: D5354-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: R66 Fwd Clamp Assembly, LH

Start Date: 01/06/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 01/11/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: _____	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.03							
Quality Control									

2017-161001

JAN 13 2017

Picklist Print

Page 1

Friday, January 06, 2017 10:43:16 AM

Work Order ID: 155062

155062

Parent Item: D5354-041

D5354-041

Parent Item Name: R66 Fwd Clamp Assembly, LH

Start Date: 01/06/2017

Required Date: 01/11/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 16.01.05 NEW ISSUE DD VERF:JLM IPP
REV:B 16.01.26 REV.A DWG DD VERF:JLM IPP REV:C
16/07/08 Per rev.B dwg. JFS Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50 0		Purchased	No			100	f	11.7564	0.354	0.745263			
M6061T6B1 250X04 500													
6061-T6 Bar 1.25 X 4.50													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT004	11.7564						
						m133038	0.3014						
						m134776	11.455						
D5316-1		Manufactured	No			160	Each	1.0000	1	2			
D5316-1													
T-Bolt Strap													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST163	1						
						152000	1						
D5351-1		Manufactured	No			160	Each	5.0000	2	4			
D5351-1													
T-Bolt Spacer													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						prelim	5						
						140611	5						

DAS
14
9-89

17/01/07

DAS
30
9-89

JAN 10 2017

B155066

(2)

DAS
30
9-89

JAN 10 2017

B155070

(4)

Picklist Print

Page 2

Friday, January 06, 2017 10:43:16 AM

Work Order ID: 155062

155062

Parent Item: D5354-041

D5354-041

Parent Item Name: R66 Fwd Clamp Assembly, LH

Start Date: 01/06/2017

Required Date: 01/11/2017

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Purchased

No

160

Each

1,352.000

2

4

MS21043-3

Nut

**

DAS
30
9-89

JAN 10 2017

Location

Loc Qty

Loc Code

CCK007

361

m135864

361

FG

80

103691

80

FP001

403

m130673

11

m136182

392

GA

39

m133990

39

ST302

400

m136295

400

ST304

69

m131340

69

4

NAS1149D0332J

Purchased

No

160

Each

1,481.000

2

4

NAS1149D0332.J

Washer

**

DAS
30
9-89

JAN 10 2017

Location

Loc Qty

Loc Code

FP001

92

m134848

92

GA

146

m134848

146

ST260a

1200

m136015

1200

ST264

43

m135672

43

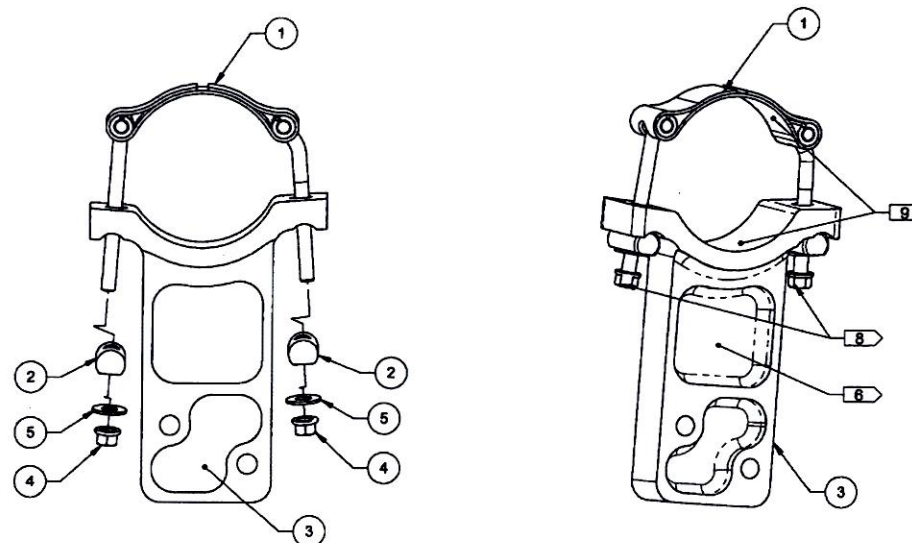
4

Friday, January 06, 2017 10:43:16 AM

Shop Packet Print

Page 2

ITEM	QTY	P/N	DESCRIPTION
	X	D5354-041	R66 FWD CLAMP ASSY, LH
1	1	D5316-1	T-BOLT STRAP
2	2	D5351-1	T-BOLT SPACER
3	1	D5354-1	SUPPORT, LH
4	2	MS21043-3	NUT, SELF-LOCKING
5	2	NAS1149D0332J	WASHER
6	A/R	PROSEAL 890	SEALANT



D5354-041 R66 FWD CLAMP ASSY, LH

NOTES:

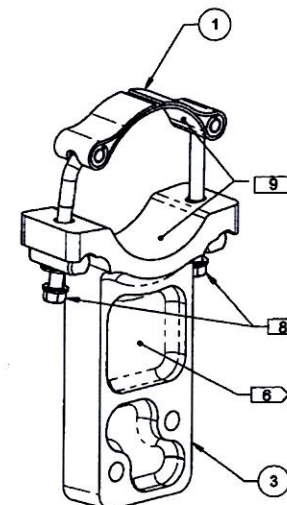
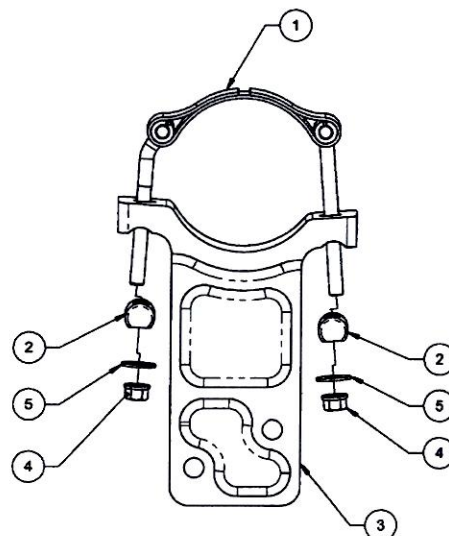
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.37 lbs
- 8) SECURE NUTS WITH 1-2 THREAD AS SHOWN
- 9) APPLY AN EVEN LAYER OF PROSEAL 890 (0.02" - 0.03" THICK) ON INSIDE SURFACE

RELEASED
2016-06-29
ECN 16-579

APPROVED

B	REDESIGN -1/-041, ADD -2/-042, REMOVE -043 (ZN A5-1, A5-2, A5-3, A5-4); ADD NOTE 9 (ZN A5-1, A5-2)	RF	16.05.24
A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5354	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 FWD CLAMP ASSEMBLY	NTS
DATE	16.05.24	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	P/N	DESCRIPTION
	X	D5354-042	R66 FWD CLAMP ASSY, RH
1	1	D5316-1	T-BOLT STRAP
2	2	D5351-1	T-BOLT SPACER
3	1	D5354-2	SUPPORT, RH
4	2	MS21043-3	NUT, SELF-LOCKING
5	2	NAS1149D0332J	WASHER
6	A/R	PROSEAL 890	SEALANT



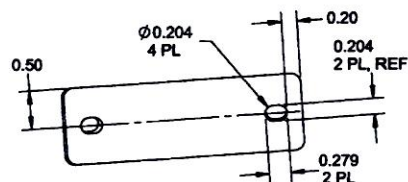
D5354-042 R66 FWD CLAMP ASSY, RH

NOTES:

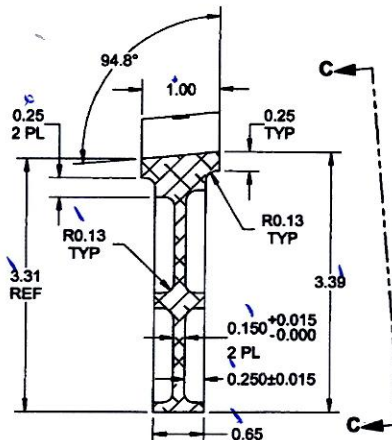
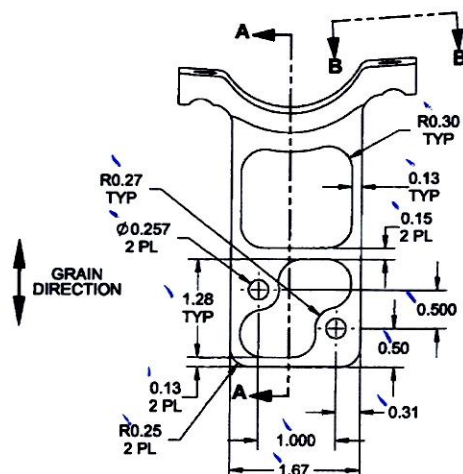
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.37 lbs
- 8) SECURE NUTS WITH 1-2 THREAD AS SHOWN
- 9) APPLY AN EVEN LAYER OF PROSEAL 890 (0.02"-0.03" THICK) ON INSIDE SURFACE

APPROVED 2016-06-29

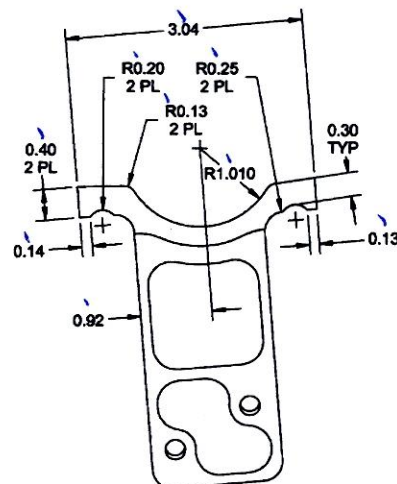
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5354	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS-#	R66 FWD CLAMP ASSEMBLY	NTS
DATE	16.05.24	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



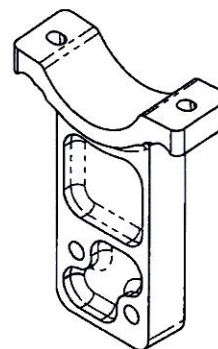
**VIEW B-B
(TYPICAL)**



SECTION A-A



VIEW C-C



D5354-1 SUPPORT, LH

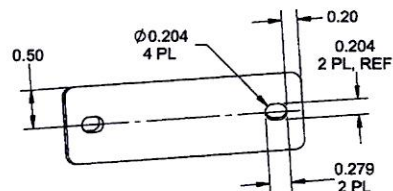
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.29 lbs
- 8) UNDEFINED FEATURES CONTROLLED BY CAD FILE D5354-1 Rev. B.SLDPR

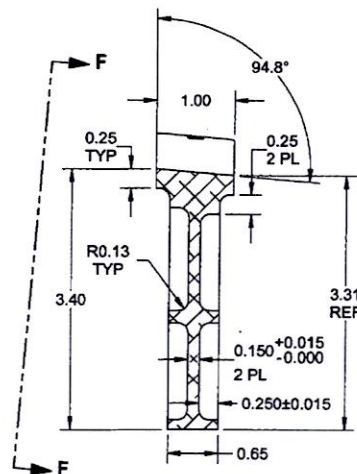
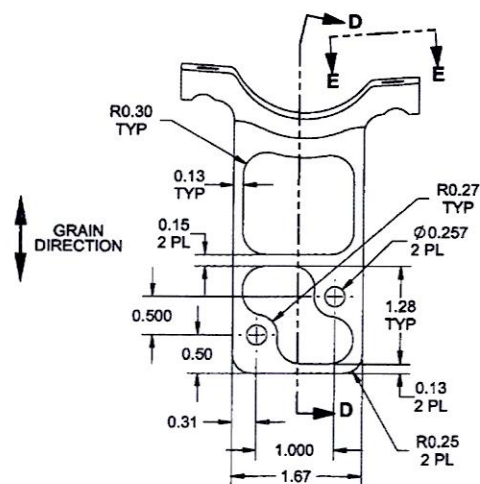
RELEASED
2016-06-29

APPROVED

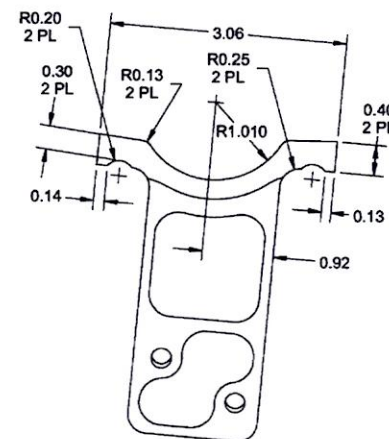
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5354	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 FWD CLAMP ASSEMBLY	NTS
DATE	16.05.24	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



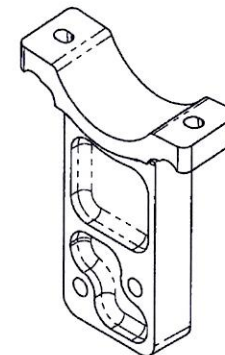
VIEW E-E
(TYPICAL)



SECTION D-D



VIEW F-F



D5354-2 SUPPORT, RH

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.29 lbs
- 8) UNDEFINED FEATURES CONTROLLED BY CAD FILE D5354-2 Rev. B.SLDPRT

RELEASED
2016-06-29

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5354	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 FWD CLAMP ASSEMBLY	NTS
DATE	16.05.24	COPYRIGHT © 2015 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DART AEROSPACE LTD		Work Order: 155062
Description: SUPPORT, LH		Part Number: D5354-1
Inspection Dwg: D5354 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.50	±.030	.500	—		Verm M1-06	
Ø.204	±.005	.206	—		"	
.20	±.030	.198	—		"	
.279	±.010	.278	—		"	
.13	±.030	.123	—		"	
.15	±.030	.150	—		"	
.500	±.005	.500	—		"	
.50	±.030	.500	—		"	
.31	±.030	.313	—		"	
1.000	±.005	1.000	—		"	
1.67	±.030	1.670	—		"	
R.25	±.030	R.250	—		R-G	
.13	±.030	.123	—		Verm M1-06	
1.28	±.030	1.275	—		"	
Ø.257	±.005	Ø.260	—		"	
94.8°	±1/2°	94.8°	—		"	
1.00	±.030	1.001	—		"	
.25	±.030	.250	—		"	
R.13	±.030	R.125	—		R-G	
3.39	±.030	3.395	—		Verm M1-06	
.150	±.005	.158	—		"	
.250	±.015	.247	—		"	
.65	±.030	.654	—		"	
R.13	±.030	R.125	—		R-G	
.25	±.030	.245	—		Verm M1-06	
3.04	±.030	3.042	—		"	
.30	±.030	.303	—		"	
.13	±.030	.130	—		"	
.14	±.030	.140	—		"	
.40	±.030	.396	—		"	
R.20	±.030	R.200	—		R-G	
R.13	±.030	R.125	—		"	

Measured by: 14 9-89	Checked by: 44 9-89	QC Inspector:
Date: 17/01/08	Date: 17-01-09	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	